

Date: Monday, 9/17/2007 1:49:12 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 EXTRUSION BENDING
Job Number	: 34693		
Estimate Number	: 10311		
P.O. Number	: <i>N/A</i>	Part Number	: D2620
This Issue	: 9/17/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2620 REV B
First Issue	: <i>N/A</i>	Project Number	: <i>N/A</i>
Previous Run	: 34692	Drawing Revision	: B
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/12/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	30 Um: Each
Comment	: Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26001160	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Extrusion Round 3" 206

Pick;

Qty	Part Number	Description	Batch
1	D2600-1	Extrusion Round 3"206	<i>B30249</i>

EL 7-11-6

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008

2- Cut Fwd end of tube as per Dwg D2620

EL/SR 7-11-6

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BE 07-11-07

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LG*

BE 07-11-07

30.

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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(30)

Comment: FINAL INSPECTION/W/O RELEASE

10/11/09

Job Completion



W St. 11-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 27/10/09
 QA: N/C Closed: _____ Date: _____

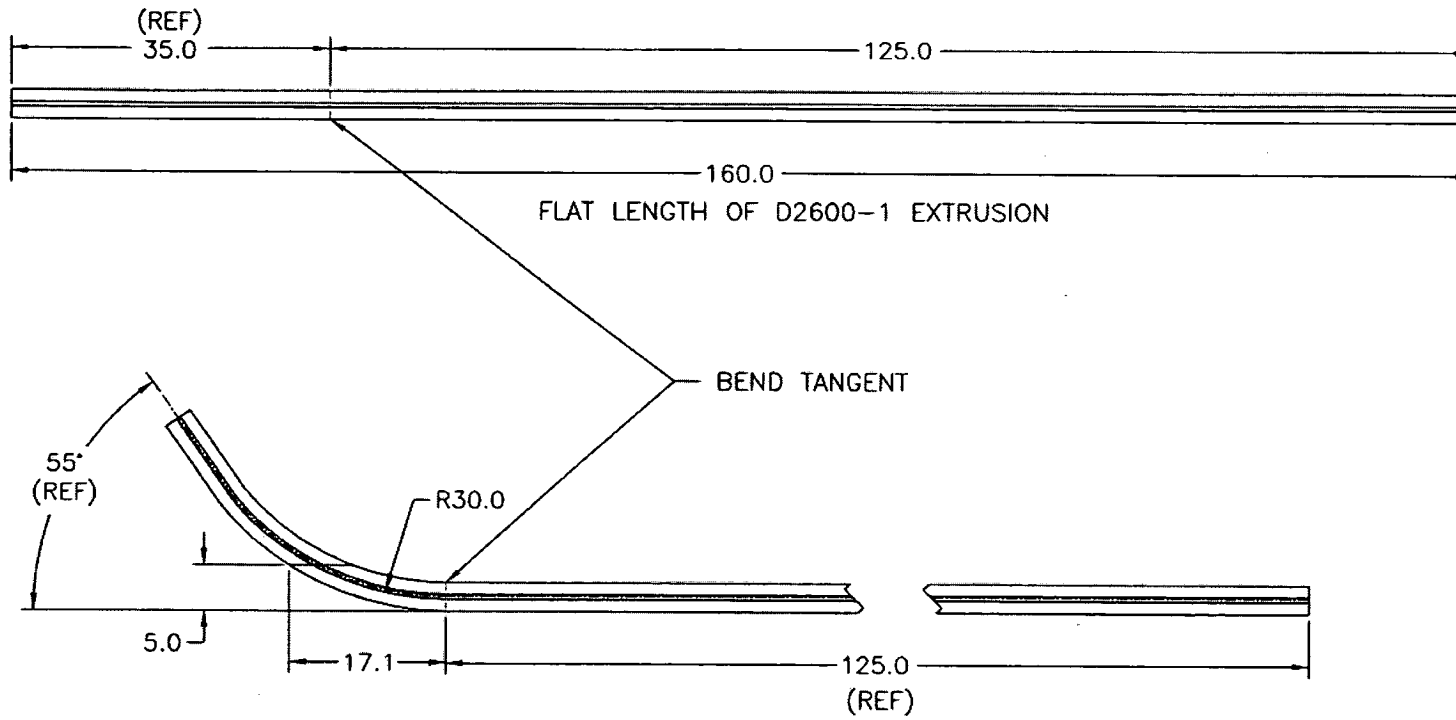
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING

DART



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0" AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH, SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DESIGN	FAIRCHILD INTERNATIONAL AIRPORT, WA	DART AEROSPACE USA, INC.
CHECKED	APPROVED	REV. B
DATE	TITLE	SHEET 1 OF 1
99.09.10	206 SKIDTUBE BENDING CONTROL	1:20
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING

RELEASED
44.04.15 DS

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NO. 34693
 WORK ORDER
 WITHOUT NOTICE
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 ENGINEERING
 RETURN TO
 SHOP COPY

